

Shp Dec 9 or sooner

Work Order ID 76638

76638

Page 1

November-18-11 10:36:24 AM

Item ID: D350-607-047A Accept *N900040100* Setup Start *NS1*
 Revision ID:
 Item Name: Heli-Utility-Basket (Automatic Lid Opener) Stop *NS2*
 Start Date: 18/11/2011 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 11/11/18 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-607-1	A

100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPPD350-607-047A CHG001								

Surlog 11-12-8 ①

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

11/12/09 ①

120	Small Fab	0.00							
120									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D350-607								

MF 11-12-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76638

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 18/11/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 09/12/2011 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

130 QC5- Inspect part completeness to step on W/O

130

OC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

0.00

0.00

0.00

0.00

140

140

Packaging

Packaging

Pick Kit

Memo

QC4- 100% Inspect kits for completeness

150

150

OC

Quality Control

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76638

76638

Page 3

November-18-11 10:36:24 AM

Item ID: D350-607-047A Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Utility-Basket (Automatic Lid Opener)
Start Date: 18/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 09/12/2011 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Packaging	0.00							
160									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-047A Location: _____								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

11/12/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-18-11 10:36:30 AM

Page 1

Work Order ID: 76638

76638

Parent Item: D350-607-047A

D350-607-047A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 18/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
as per ecn 10-545 DD 10.04.19 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D350-607-241

4167001

Manufactured No

140

Each

1.0000

1

1

D350-607-241

Basket Clamp Assembly

**

B76637
2/11-12-09

Location

Loc Qty

Loc Code

FG022

1

75267

1

D2022-101

Manufactured No

110

Each

82.0000

5

5

D2022-101

Spacer

**

W

Location

Loc Qty

Loc Code

ST504

82

71840

32

73307

50

71840

D2258-200

Manufactured No

110

Each

9.0000

1

1

D2258-200

Placard 200lb

**

76656 W

Location

Loc Qty

Loc Code

ST505

9

71180

9

D2530

Manufactured No

110

Each

9.0000

1

1

D2530

Handle Weldment

**

W

Location

Loc Qty

Loc Code

ST506

8

74600

8

ST508

1

69318

1

74600

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 76638

76638

Parent Item: D350-607-047A

D350-607-047A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 18/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

~~D2535~~
D2535
Spring

Manufactured No

110 Each

48.0000

2

2

**

Location

Loc Qty

Loc Code

ST504

48

71117

48

71117

Manufactured No

110 Each

25.0000

2

2

**

Location

Loc Qty

Loc Code

ST504

25

73344

25

73344

Manufactured No

110 Each

556.0000

2

2

**

Location

Loc Qty

Loc Code

ST504

556

46064

556

46064

Manufactured No

110 Each

0.0000

1

1

**

D3265-041

D3265-041

Basket Base Assembly

D3267-041

Manufactured No

110 Each

0.0000

1

1

**

D3267-041

Basket lid Assembly (Outside)

D3267-043

Manufactured No

110 Each

0.0000

1

1

**

D3267-043

Basket Lid Assembly (Inside)

D350-607-143

Manufactured No

110 Each

0.0000

1

1

**

D350-607-143

Automatic Lid Opener Installation

B76413 f ✓

46064

1

1

76651

76648

1

1

76648

1

1

76648

1

1

76648

1

1

76648

1

1

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 76638

76638

Parent Item: D350-607-047A

D350-607-047A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 18/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-16A
AN3-16A
Bolt

Purchased No

110 Each

139.0000 2 2

**

Location

Loc Qty

Loc Code

ST352

139

117441

53

118628

86

118628

Purchased No

110 Each

1,055.000 2 2

**

AN4-13A
AN4-13A
Bolt

Location

Loc Qty

Loc Code

ST357

1055

118078

55

118838

500

119449

500

118838

Purchased No

110 Each

216.0000 5 5

**

AN4-22A
AN4-22A
Bolt

Location

Loc Qty

Loc Code

ST359

216

116419

49

117313

67

118628

100

117313

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 76638

76638

Parent Item: D350-607-047A

D350-607-047A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 18/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-17A

Purchased

No

110

Each

140.0000

4

4

AN5-17A

Bolt

**

Location

Loc Qty

Loc Code

FP

50

119438

50

ST338

90

117872

42

119449

48

MS20600-AD4W3

Purchased

No

110

Each

1,305.000

2

2

MS20600-AD4W3

Cherry Rivets

**

Location

Loc Qty

Loc Code

GA

878

118626

878

ST321

294

111636

42

117505

217

117601

35

WA018

133

107939

133

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

November-18-11 10:36:30 AM

Page 5

Work Order ID: 76638

76638

Parent Item: D350-607-047A

D350-607-047A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 18/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

~~NAS1149D0463J~~

Purchased

No

110

Each

12,582.00

14

14

**

NAS1149D0463.I

Washer

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

12258

119075

10000

119097

2258

119075

~~NAS1149D0563J~~

Purchased

No

110

Each

5,121.000

4

4

**

NAS1149D0563.I

Washer

Location

Loc Qty

Loc Code

ST296

2000

119546

2000

ST298

3121

118206

2121

118614

1000

118206

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-18-11 10:36:30 AM

Page 6

Work Order ID: 76638

76638

Parent Item: D350-607-047A

D350-607-047A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 18/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0832J

Purchased

No

110

Each

278.0000

2

2

NAS1149D0832.J

Washer

**

118614

Location

Loc Qty

Loc Code

ST298

278

112608

78

113237

100

114348

100

~~112608~~

NAS1515H4

Purchased

No

110

Each

183.0000

2

2

NAS1515H4

Washer

**

Location

Loc Qty

Loc Code

ST277

183

116169

3

117460

29

117735

3

118078

48

118612

100

117460

MS21042L3

Purchased

No

110

Each

8,736.000

2

2

MS21042L3

Nut

**

11/12/11

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2481

119075

2481

119075

November-18-11 10:36:30 AM

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Page 6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-18-11 10:36:30 AM

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Work Order ID: 76638

76638

Parent Item: D350-607-047A

D350-607-047A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 18/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased No

110

Each

11,444.00

7

7

MS21042L4

**

Nut

Location

Loc Qty

Loc Code

ST300

552

117441

51

117601

368

118451

133

ST516

5892

119017

5892

119017

ST518

5000

119075

5000

MS21042L5

Purchased No

110

Each

2,280.000

4

4

MS21042L5

**

Nut

Location

Loc Qty

Loc Code

ST300

780

116105

5

116548

43

117611

52

118179

496

118910

184

118910

ST518

1500

119109

1500

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

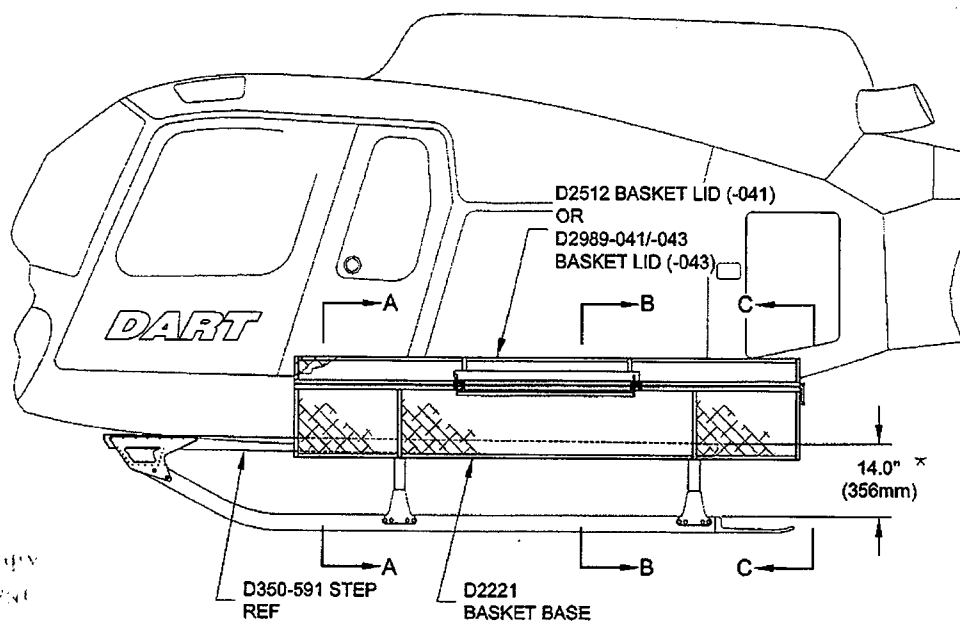
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

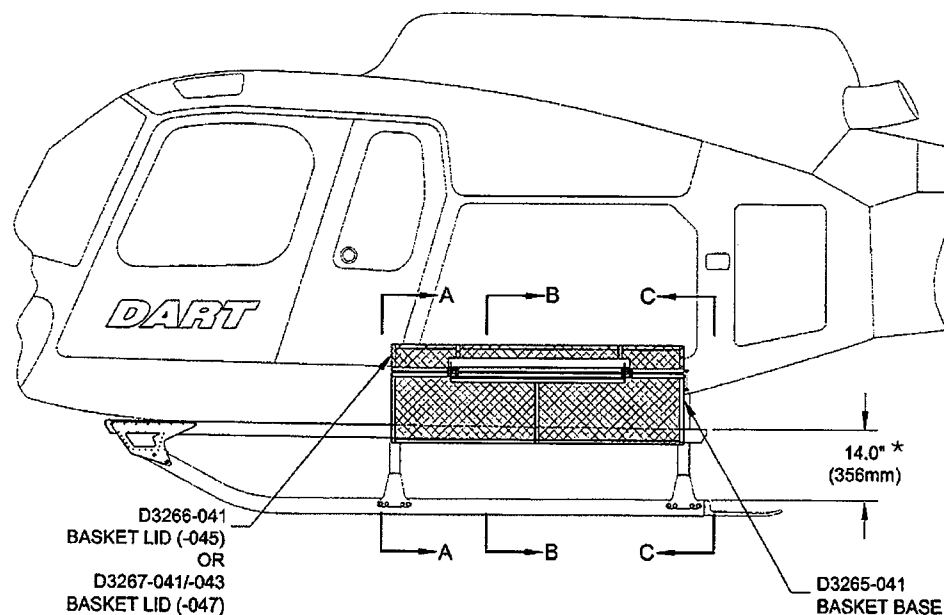
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76638-M.L.J
11/11/17



**Figure 1a – D350-607-041 Heli-Utility-Basket™ Installation, or
D350-607-043 Heli-Utility-Basket™ Installation**
(LH Installation Shown, RH Opposite)



**Figure 2a – D350-607-045 Heli-Utility-Basket™ Installation, or
D350-607-047 Heli-Utility-Basket™ Installation**
(LH Installation Shown, RH Opposite)

* Proper position for step installation on high gear only

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Revision: A

Date: 10.03.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

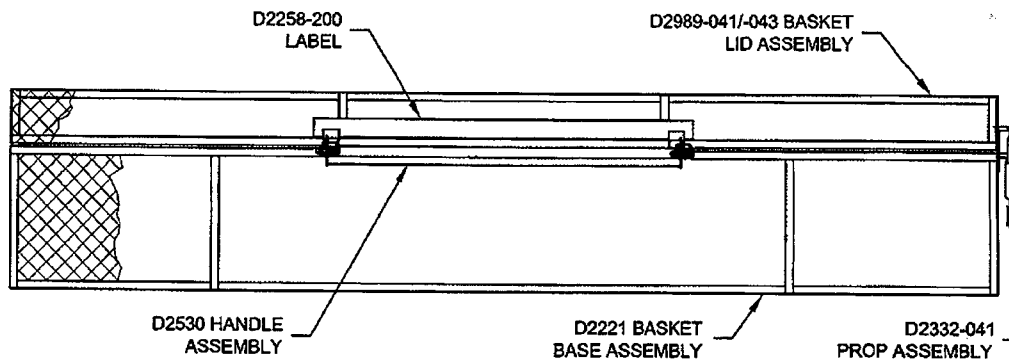
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

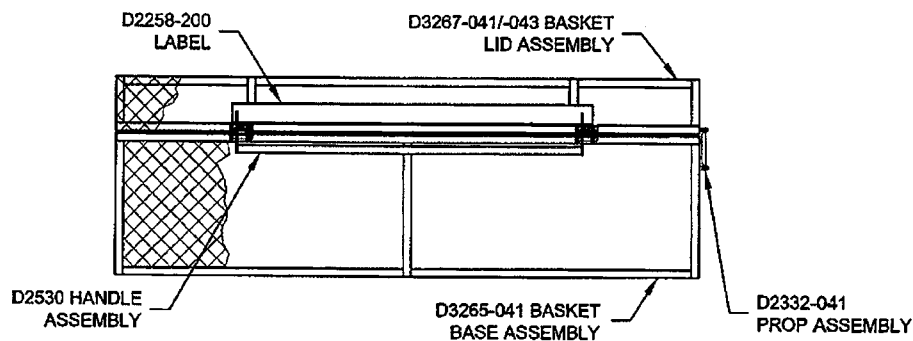
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

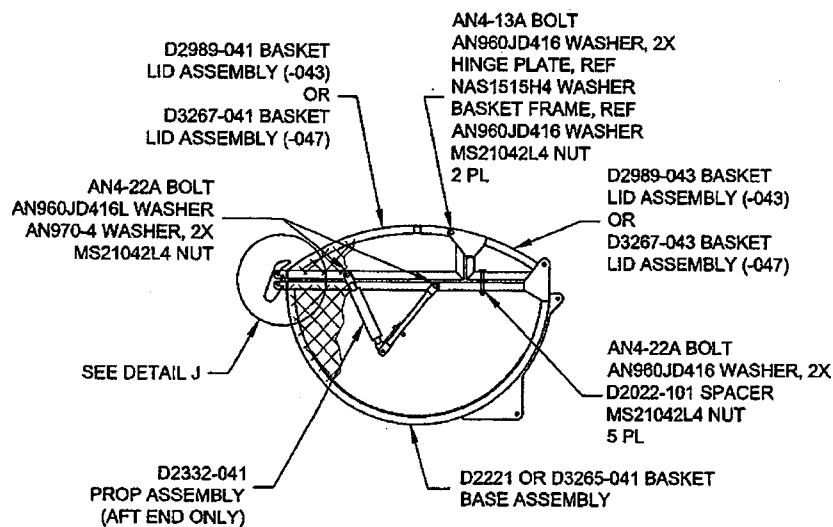
76638



D350-607-043 HELI-UTILITY- BASKET™



D350-607-047 HELI-UTILITY- BASKET™



VIEW C-C
PROP ARM DETAIL

Figure 6- Basket Replacement Parts

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Revision: **A**
Date: 10.03.10

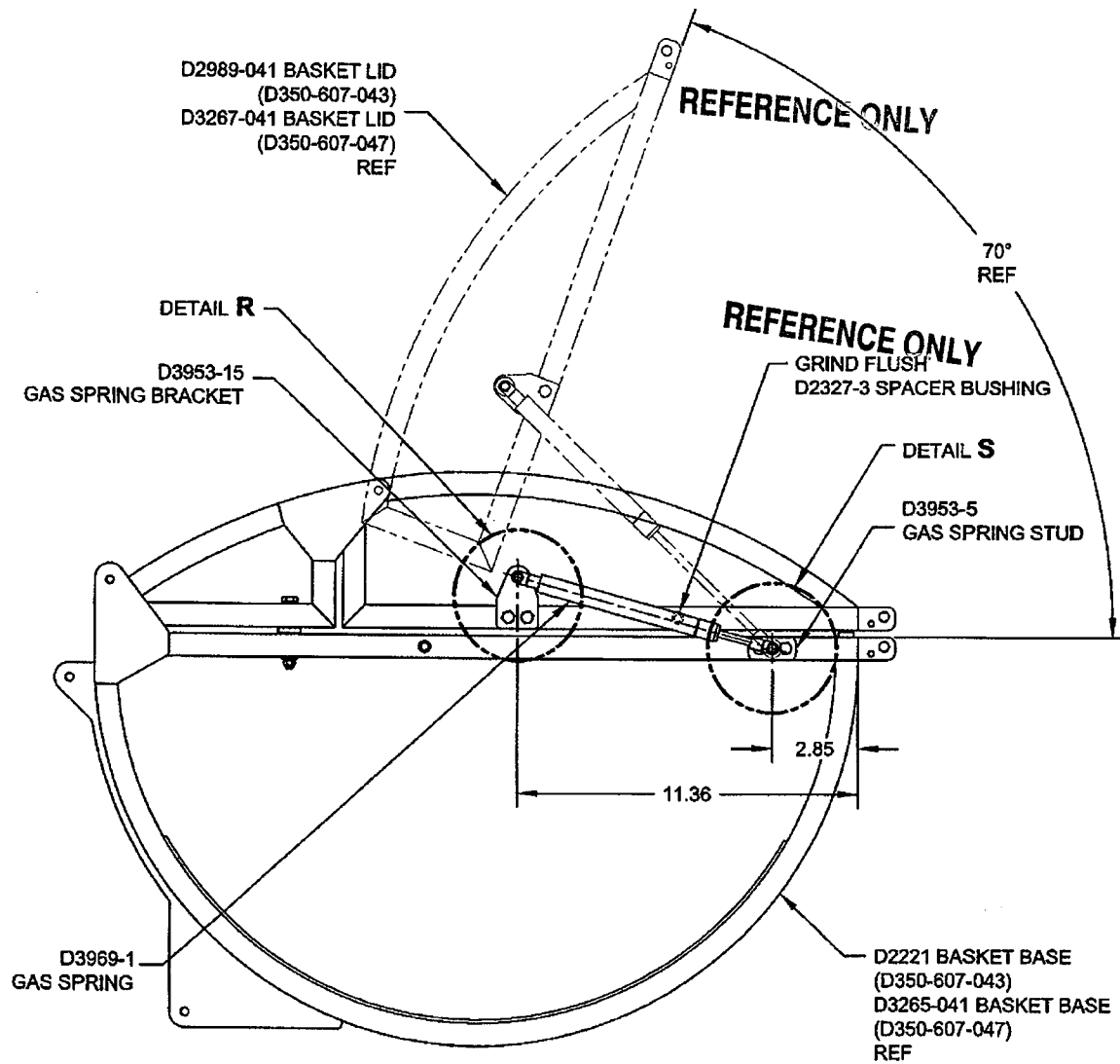
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-607-143 AUTOMATIC LID OPENER INSTALLATION

(1 END ONLY)

Figure 9a – Automatic Lid Opener Installation

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Revision: **A**

Date: 10.03.10

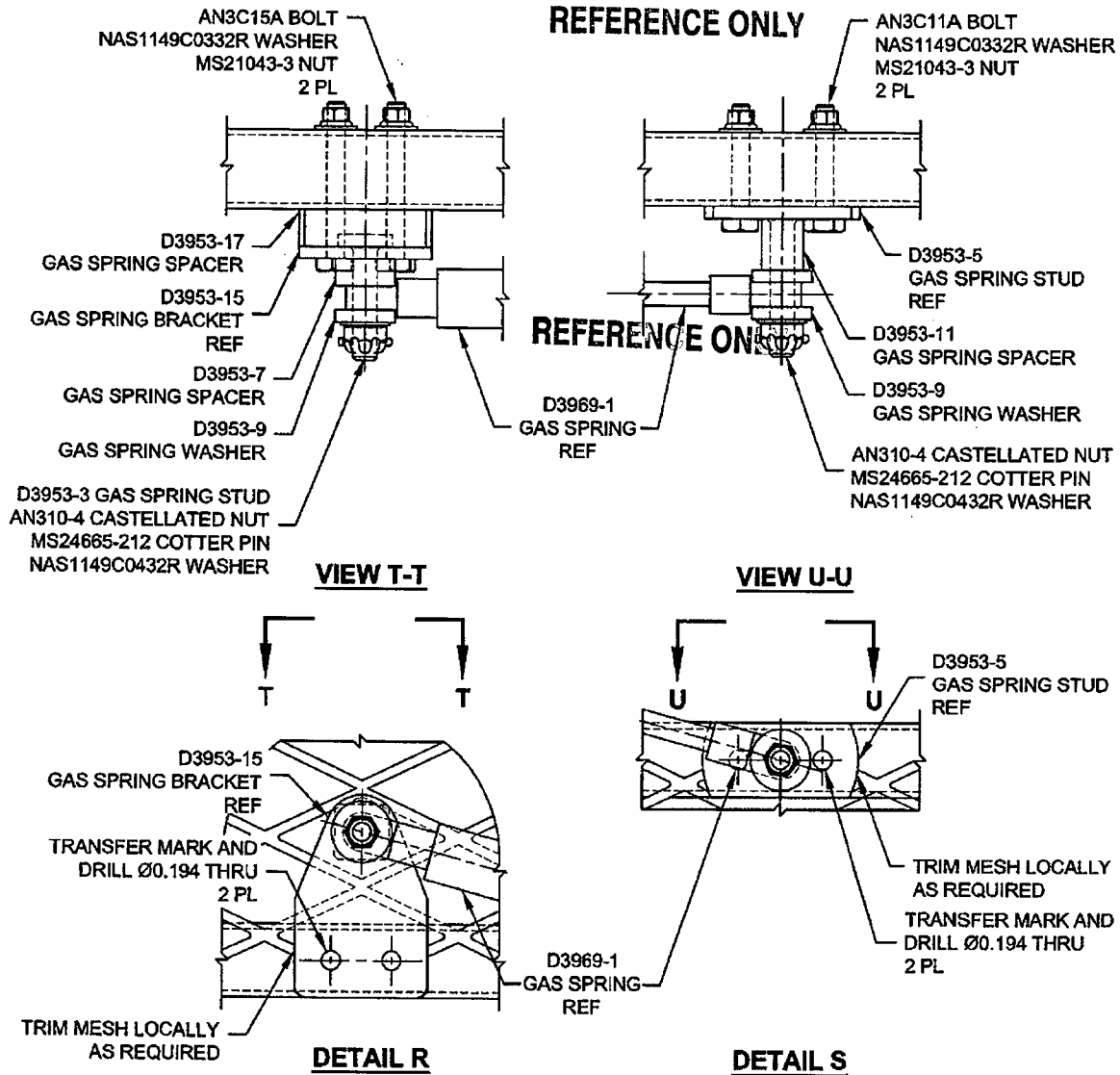


Figure 9b – Automatic Lid Opener Installation

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Revision: A

Date: 10.03.10